

401.32

Dart Aerospace Ltd.

Date: Tuesday, 7/17/2007 2:00:18 PM
 User: Kim Johnston

Process Sheet

①

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 33588	
Estimate Number : 11737	
P.O. Number : N/A	Part Number : D27952
This Issue : 7/17/2007 S.O. No. : N/A	Drawing Number : D2795 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : N/A	Material : N/A
Type : MACHINED PARTS	Due Date : 8/3/2007
Written By : _____	Qty: 21 Um: Each
Checked & Approved By : <u>7.07.17</u>	
Comment : Est. A 01.02.05 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.3913 f(s)/Unit Total : 29.2163 f(s)
 6061-T6 Bar .50" x 6.0"
 Material: 6061-T6 (QQ-A-200/8) 0.500" thick
 (M6061T6B0.500x06.000)
 Identify for D2795-2
 Batch: M105145

104326 X8 BC 07-08-07 21

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 15.800" long

BC 07-08-07 21

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio FA106
 Tumble & Deburr

BC 07-08-07 21

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC 07-08-07 21

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ML 07/08/06 21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/08/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 2:00:18 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 33588

Part Number: D27952

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C-78/7 (21)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(21)

Comment: FINAL INSPECTION/W/O RELEASE

D27952/08/08

Job Completion



Jul/07-08-07.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	33588
Description: Arm		Part Number:	D2795-2
Inspection Dwg: D2795 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.000	✓			
6.049	+/-0.010	6.047	✓			
R0.030	+/-0.010	.03	✓			
Ø0.191	+0.005/-0.000	.192	✓			
2.311	+/-0.010	2.310	✓			
0.250	+/-0.010	.255	✓			
9.358	+/-0.005	9.363	✓			
Ø0.507	+0.000/-0.001	.507	✓			
2.033	+/-0.005	2.036	✓			
1.000	+/-0.010	1.002	✓			
2.500	+/-0.010	2.499	✓			
1.347	+/-0.010	1.347	✓			
0.250	+/-0.010	.255	✓			
R0.125	+/-0.010	.125	✓			
Ø0.375 x 100°	+/-0.005	.380	✓			
0.500	+/-0.010	.500	✓			

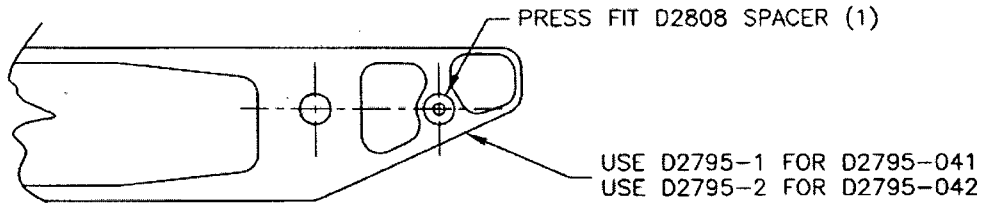
Measured by: <i>SG</i>	Audited by: <i>DMK</i>	Prototype Approval:	N/A
Date: 07/08/04	Date: 07/08/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.10	New Issue	KJ/RF <i>RF</i>	<i>RF</i>

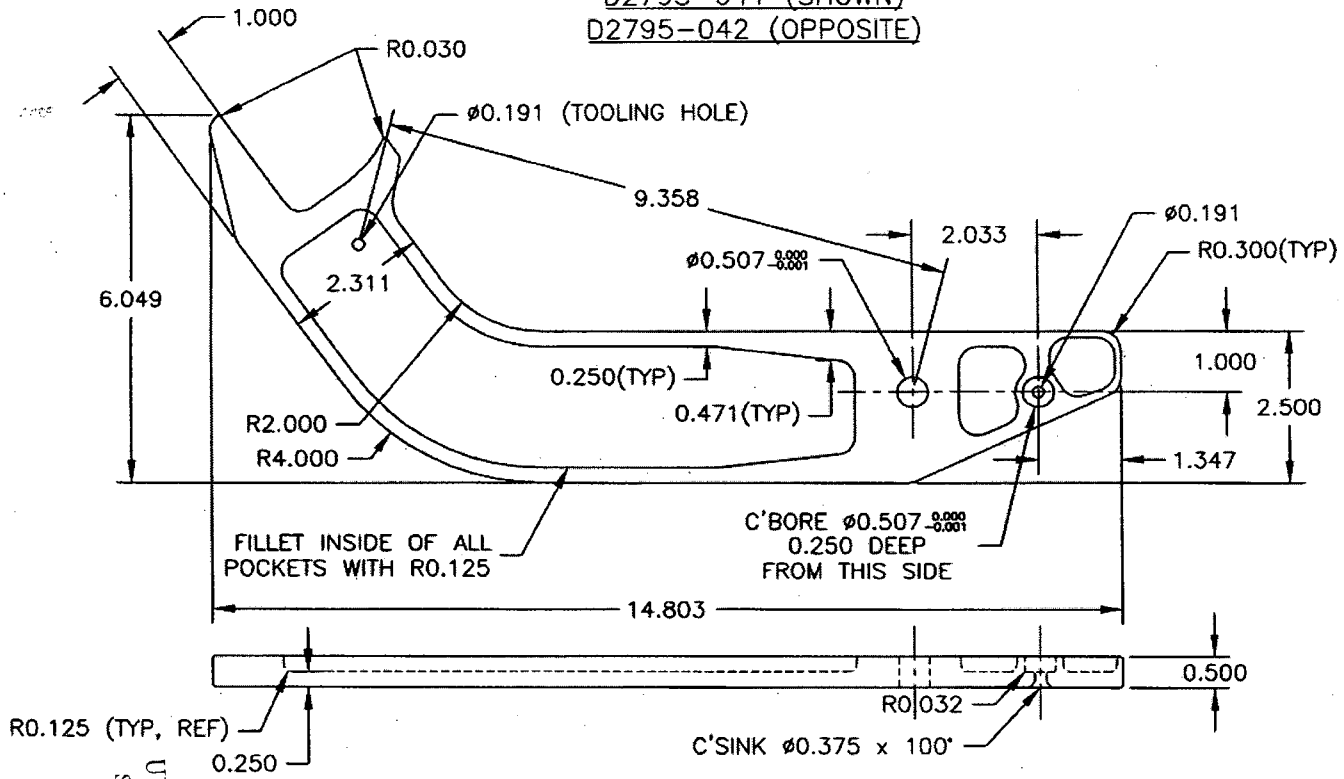


DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	HAMKESBURY, ONTARIO, CANADA	
DATE	TITLE	DRAWING NO.	REV. A
00.11.03	ARM	D2795	SHEET 1 OF 1
A	00.11.03	NEW ISSUE	SCALE 1:3

RELEASED
00.11.13



D2795-041 (SHOWN)
D2795-042 (OPPOSITE)



D2795-1 (SHOWN)
D2795-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2795-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33588

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